

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE FITTING, AFT (OUTBOARD/INBOARD)
Job Number	: 30594		
Estimate Number	: 10533		
P.O. Number	: N/A	Part Number	: D2573
This Issue	: 2/5/2007      S.O. No. : N/A	Drawing Number	: D2573 REV E
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A      Type : MACHINED PARTS	Drawing Revision	: E
Previous Run	: 30214	Material	: N/A
Written By	: _____	Due Date	: 2/9/2007      Qty:      12 Um:      Each
Checked & Approved By	: _____		
Comment	: Est: I As Per RevE 06-01-27 JLM		

### Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101007	7075-T7351 8.25X7.75X2.5
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**Comment:** Qty.: 1.0000 Each(s)/Unit      Total : 12.0000 Each(s)

7075-T7351 8.25X7.75X2.5

Make from D6101-007 billet for D2573

Ensure that grain is along 7.75" length

Batch No: 25355

BE 07.04.16 13

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



**Comment:** HAAS CNC VERTICAL MACHINING #1

Program Batch No. 26 Double check by: Int

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per

Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets

4-Deburr and remove all machining marks

5-Tumble to remove sharp edges.

BC/Kr 67041102 (12)

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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**Comment:** CONVENTIONAL MILLING MACHINE

Machine keyway as per dwg D2573 &amp; D2574

36/19 07.04.19 12

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

36 / EP 07.04.19 (12)

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 09/04/24  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 2/5/2007 8:07:02 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 30594

Part Number: D2573

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

MS 07/04/19

(12)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FEL

07/04/20

(12)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M1103706

HS

07-04-20

(12)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

PU

7/4/23

59

(12)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

PU

7/4/23

59

(12)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/04/24

(12)

Job Completion



07-04-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	30594
<b>Description:</b> Saddle, Aft Outboard	<b>Part Number:</b>	D2573
<b>Inspection Dwg:</b> D2573 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.440	0.440	0.440	0.440		
B	1.745	1.755		1.750	1.750	1.748	1.746		
C	3.495	3.505		3.500	3.500	3.499	3.503		
D	1.745	1.755		1.750	1.750	1.748	1.746		
E	7.990	8.010		8.000	8.000	8.002	8.003		
F	0.490	0.510		0.502	0.500	0.493	0.498		
G	0.257	0.262	DT8683	0.260	0.260	0.260	0.266		
H	0.375	0.380	DT8684	0.376	0.376	0.377	0.377		
I	0.490	0.510		0.503	0.504	0.501	0.502		
J	1.174	1.184		1.179	1.179	1.178	1.175		
K	0.558	0.578		0.570	0.569	0.566	0.563		
L	1.174	1.184		1.179	1.179	1.178	1.175		
M	1.365	1.375		1.370	1.370	1.367	1.366		
N	2.495	2.505		2.500	2.500	2.499	2.498		
O	4.119	4.129		4.124	4.124	4.119	4.122		
P	0.115	0.135		0.124	0.129	0.129	0.129		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.255	0.255	0.254	0.253		
S	0.115	0.135		0.122	0.132	0.132	0.131		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.240	0.244	0.235	0.236		
W	0.115	0.135		0.131	0.135	0.130	0.128		
X	0.308	0.313		0.310	0.310	0.311	0.311		
Y	0.760	0.765		0.762	0.762	0.765	0.765		
Z	0.352	0.372		0.365	0.365	0.365	0.367		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.633	0.635	0.629	0.633		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.250	0.257	0.246	0.246		
AE	1.500	1.520		1.520	1.515	1.513	1.515		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.250	0.250	0.260	0.260		
AH	0.240	0.260		0.250	0.255	0.246	0.249		
AI	2.000	2.020		2.005	2.002	2.000	2.000		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by: <i>EP</i>
Date: <i>07/04/17</i>

Audited by: <i>SA</i>
Date: <i>07.04.17</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>30594</b>
<b>Description:</b> Saddle, Aft Outboard	<b>Part Number:</b>	<b>D2573</b>
<b>Inspection Dwg:</b> D2573 Rev. E		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.440	0.440	0.440	0.440		
B	1.745	1.755		1.748	1.748	1.749	1.748		
C	3.495	3.505		3.501	3.500	3.500	3.500		
D	1.745	1.755		1.748	1.748	1.749	1.748		
E	7.990	8.010		8.003	8.003	8.003	8.005		
F	0.490	0.510		0.502	0.496	0.495	0.499		
G	0.257	0.262	DT8683	0.260	0.260	0.260	0.260		
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377		
I	0.490	0.510		0.502	0.500	0.503	0.501		
J	1.174	1.184		1.178	1.176	1.175	1.178		
K	0.558	0.578		0.566	0.564	0.568	0.564		
L	1.174	1.184		1.178	1.176	1.175	1.178		
M	1.365	1.375		1.367	1.368	1.367	1.366		
N	2.495	2.505		2.495	2.498	2.497	2.497		
O	4.119	4.129		4.122	4.121	4.121	4.120		
P	0.115	0.135		0.128	0.128	0.127	0.127		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.252	0.252	0.252	0.252		
S	0.115	0.135		0.129	0.127	0.122	0.124		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.240	0.237	0.237	0.238		
W	0.115	0.135		0.125	0.124	0.126	0.126		
X	0.308	0.313		0.311	0.310	0.311	0.311		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.360	0.362	0.361	0.361		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.634	0.627	0.627	0.627		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.250	0.247	0.244	0.245		
AE	1.500	1.520		1.513	1.515	1.514	1.512		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.251	0.250	0.247	0.248		
AI	2.000	2.020		2.003	2.005	2.003	2.002		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	Ep
Date:	07/04/18

Audited by:	SD
Date:	07.04.18

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	30594
<b>Description:</b> Saddle, Aft Outboard		<b>Part Number:</b>	D2573
<b>Inspection Dwg:</b> D2573 Rev. E		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

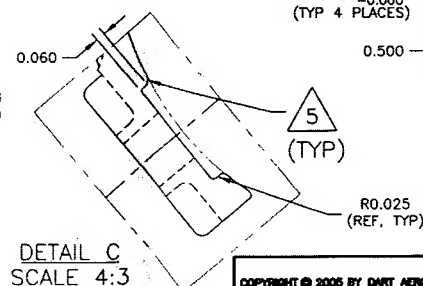
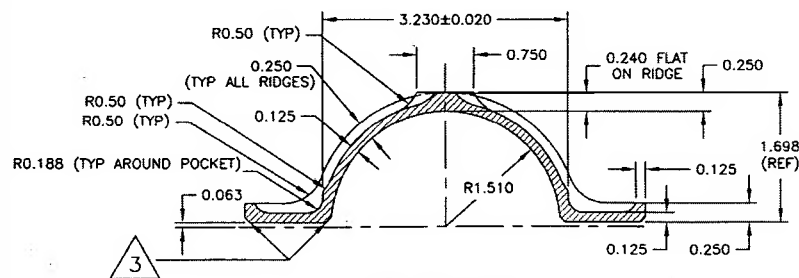
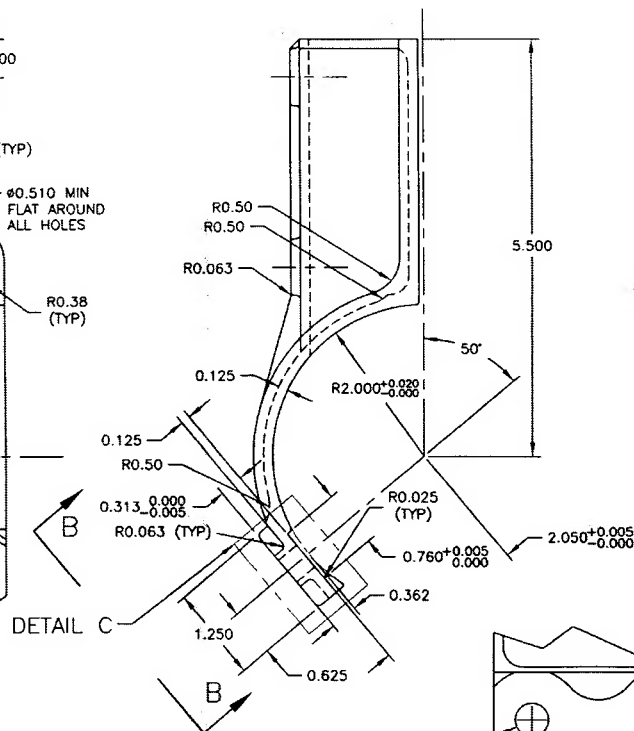
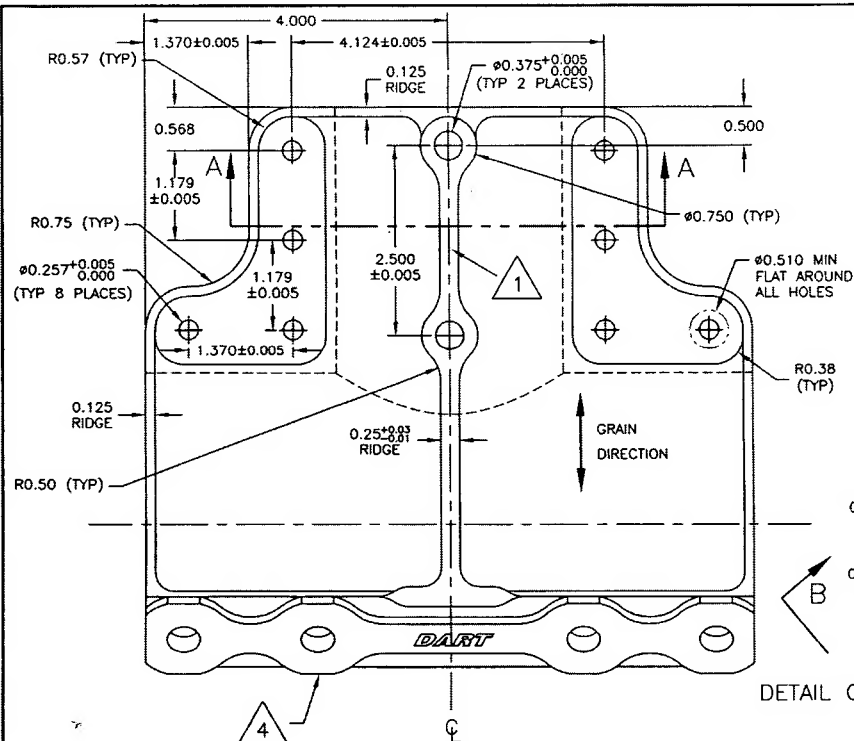
				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.440	0.440	0.440	0.440		
B	1.745	1.755		1.749	1.750	1.750	1.750		
C	3.495	3.505		3.501	3.500	3.500	3.500		
D	1.745	1.755		1.749	1.750	1.750	1.750		
E	7.990	8.010		8.004	8.003	8.003	8.003		
F	0.490	0.510		0.496	.500	.500	.500		
G	0.257	0.262	DT8683	0.260	0.260	0.260	0.260		
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377		
I	0.490	0.510		0.501	.500	.500	.500		
J	1.174	1.184		1.177	1.179	1.179	1.179		
K	0.558	0.578		0.564	.564	.564	.564		
L	1.174	1.184		1.177	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.499	2.500	2.500	2.500		
O	4.119	4.129		4.122	4.122	4.122	4.122		
P	0.115	0.135		0.128	.128	.128	.128		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.253	.250	.250	.250		
S	0.115	0.135		0.123	.123	.123	.123		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.236	.236	.236	.210		
W	0.115	0.135		0.125	.125	.125	.125		
X	0.308	0.313		0.310	.310	.310	.310		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.366	.366	.366	.366		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.629	.629	.629	.629		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.244	.244	.244	.244		
AE	1.500	1.520		1.514	1.514	1.514	1.514		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.248	.250	.250	.250		
AI	2.000	2.020		2.004	2.004	2.004	2.004		
AJ	0.023	0.043		0.038	0.033	0.033	0.033		
Accept/Reject									

Measured by:	EN / TSC
Date:	07/04/19

Audited by:	MS
Date:	07/04/19







Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

05.12.06

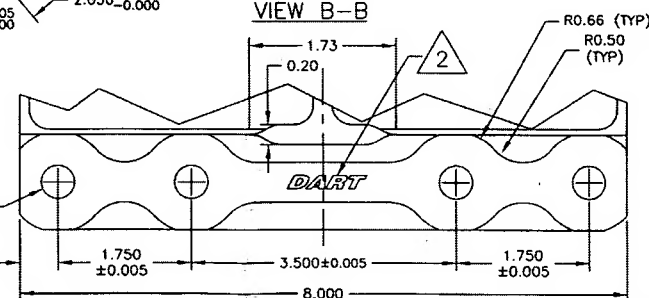





## NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)  
(REF DART SPEC. D6102-001)  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER  
DART QSI 005 4.3  
BREAK ALL SHARP EDGES 0.010 TO 0.020  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- |   |   |
|---|---|
|  | ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010  |
|  | ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125  |
|  | CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)   |
|  | CHAMFER 0.063" x 45° ALL AROUND   |
|  | CHAMFER 0.033" x 45° (SEE DETAIL C)  |

VIEW B-B



E	05.07.13	ADD CHAMFER ON RIDGE NOTE 5
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN		 <b>DART AEROSPACE LTD.</b> MARKHAM, ONTARIO, CANADA
DRAWN BY		
DS	PH	
CHECKED 	APPROVED 	DRAWING NO. <b>D2573</b>
DATE		TITLE <b>OUTER AFT SADDLE</b>
05.07.13		SCALE 3/4" = 1"

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WITHOUT NOTICE  
WORK ORDER  
NO. 30594